



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBEM625V3006101-1
Job Sheet 173659



Part No: RBEM625V3006101-1

Job Qty: 1 ea

Part Name: Base



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/30/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: RBEM625V3006101-1 REV.C SHEET 2 IPP Rev.A 17.09.06 New issue DP Verify DD IPP Rev:B 17.11.16 AS
PER DWG REV.C DD VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		3/15/18	0.00	0.00	Start Up Machining-2		
110	Bandsaw	1 pcs		3/15/18	0.00	0.10	Bandsaw1		
120	CNC Lathe	1 pcs		3/16/18	0.00	1.00	MORI SL2500Y		
130	QC	1 pcs		3/16/18	0.00	0.00	QC2 Machining-4		
140	QC	1 pcs		3/16/18	0.00	0.00	QC8 Machining-4		
150	QC	1 pcs		3/16/18	0.00	0.00	QC5		
170	Outsource	1 pcs		3/30/18			MEI001-VC	10	
180	Outsource	1 pcs		3/30/18			GRO002-VC		
190	Packaging	1 pcs		3/30/18	0.00	0.00	Packaging2		
200	QC	1 pcs		3/30/18	0.00	0.00	QC6		
210	Packaging	1 pcs		3/30/18	0.00	0.00	Packaging3-1		
220	QC21-SA	1 Ea		3/30/18	0.00	0.00	QC21		

Part Op 120 - 1-Machine as per Folio:FB616 FOLIO REV: DWG REV: 2-DEBURR

Descriptions: 150 - Engrave S/N number And/or T/N number as required Using Marktronic engraver as per DWG.

170 - P/O to Meteor: P/O 39933 heat treat to RC28-32, bead blast after heat treat, part made from 4140 H round bar Certificate of Conformity is required ship to Groupe Altech

180 - Issue P/O to Groupe Altech: P/O - Zinc plate, ASTM B633 TYPE 1 SC2 - Certificate of Conformity is required

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M4140H-R8.000	4140 round bar 8.000	1060 ft (.106 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part
90-Start up Operation	M4140H-R8.000

Part Specific

Specifications could



Container No: S066640



Part: RBEM625V3006101-1

Job No: 173659

Serial No/Batch: S066640

Revision: C

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DQA: _____ Date: _____

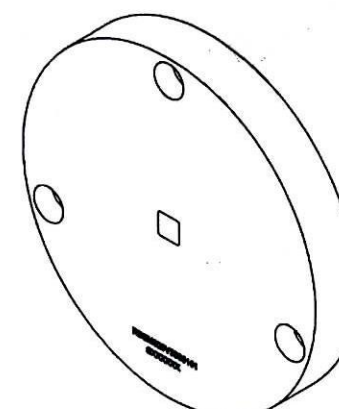


WORK ORDER NON-CONFORMANCE / UPDATE

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AC076

NO. 173659 *u*
120180424



NOTES:

1) MATERIAL: AISI 4140/4142	SECTION A-A
2) HEAT TREAT: 28-32 Rc	
3) FINISH: ZINC PLATE	
4) SPEC: ASTM B833 TYPE I, SC 2	
5) BREAK ALL SHARP EDGES .015 x 45° OR .015R	
6) IDENTIFICATION: MACHINE ENGRAVE T/M "RBEM625V3006101" & S/N, ARIAL REGULAR, 1/8" HEIGHT, 0.010" DEPTH	

		Hawthornbury, Ontario, Canada	
TITLE BASE			
DWO NO. RBEM625VS3006101-1		REVISION 1	
DESIGN BY:	VM 10/5/2017	XXX X .005	FRACTIONS & 1/8
DRAWN BY:	VM 11/06/2017	JOX X .1	ANGLES & 15
CHECKED:	SAC 1/18/2017	JOX X .1	SURFACES & 12
MFG. APPR:	DP 11/06/2017	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED	
APPROVED:	VM 11/10/2017	2. INTERPRET DON AND TOL PER ASME Y14.5-2009	
DATE:	1/18/2017	3. DIMENSIONAL LIMITS APPLY TO ALL PLATING	
SCALE:	NTS	WEIGHT:	8.025 LBS
SHEET 2 OF 2			

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Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐																																																																							
Contamination ☐	Out of Sequence ☐	Part Moved ☐																																																																							
Countersink ☐	Off-set ☐	Drawing ☐																																																																							
Cut Too Short ☐	Mislabeled ☐	Finish ☐																																																																							
Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐																																																																							
Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																																																																							



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039833**

Supplier: ATL002-VC
Atlantic Heat Treat 2001
401 Frankcom
Ajax
ON
L1S R14 Canada
Phone: 866 257 6395

PO No: PO039833
PO Date: 5/8/18
Due Date: 5/11/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Pynt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	176875	C2-3-3	Latch Roller 1-Issue P/O to Atlantic Heat Treat; P/O _____ RC 53-56 2-Bead blast 3- Certificate of Conformity is required -Material:4140	Firmed	5/11/18	20 pcs	0 pcs	20 pcs	\$0.01/pcs	\$0.20
2	175633	C3-3-4	Link Pin 1-Issue P/O to Atlantic Heat Treat; P/O _____ RC 53-56 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Atlantic Heat Treat to ship directly to Groupe Altech*** Material: Drill Rod	Firmed	5/11/18	30 pcs	0 pcs	30 pcs	\$0.01/pcs	\$0.30
3	176725	C10-8	Trunnion Bushing 1-Issue P/O to Atlantic Heat Treat; P/O _____ RC 37-40 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Atlantic Heat Treat to ship directly to Groupe Altech -Material:4140	Firmed	5/11/18	20 pcs	0 pcs	20 pcs	\$0.01/pcs	\$0.20

Items										
Line Item	Job	Part	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	173605	RB877206-5-7	Cutter 1-Issue P/O to Atlantic Heat Treat ; P/O _____ RC 50-60 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO GRINDER Atlantic Heat Treat to ship directly to KG grinding. -Material:O1 TOOL STEEL	Firmed	5/11/18	8 pcs	0 pcs	8 pcs	\$0.10/pcs	\$0.80
5	173659	RBEM625V3006101-1	Base P/O to Atlantic Heat Treat: P/O _____ heat treat to RC28-32, bead blast after heat treat, part made from 4140 H round bar Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. - Certificate of Conformity is required	Firmed	5/11/18	7 pcs	0 pcs	7 pcs	\$19.50/pcs	\$136.50
6	173762	RBEM642V4001102-15	Wrench Weldment 1-Issue P/O to Atlantic Heat Treat; P/O _____ RC 46-50 2-Bead blast 3-Black oxide finish, MIL-C-13924C Class 1 -Apply thin layer of oil/CPC per MIL-PRF-16173 Grade 3 Class 1 or MIL-c-81309 Type III Or MILL-C23411A or MIL-PRF-81309 and wipe off excess. - Certificate of Conformity is required -Material:4140	Firmed	5/11/18	4 pcs	0 pcs	4 pcs	\$19.50/pcs	\$78.00
7	176656	RBT18591-5	Puller Rod 1-Issue P/O to Atlantic Heat Treat; P/O _____ RC 32-42 2-Bead blast 3- Certificate of Conformity is required ***NOTE*** DROP SHIP TO FINISHER Atlantic Heat Treat to ship directly to Groupe Altech*** -Material:B7 ALL-THREAD	Firmed	5/11/18	10 pcs	0 pcs	10 pcs	\$0.01/pcs	\$0.10
Grand Total:										\$216.10

Order Notes

Certification

Date: 15/05/2018

Entry Date: 15/05/2018

Page: 1 of 1

To:DART AEROSPACE LTD.
1270 ABERDEEN ST

Purchase Order No.: po039796

Packing List No.:

HAWKESBURY ON K6A 1K7

Material: 4140

We are pleased to provide you with the following Certificate of Compliance.

Quantity	Part Number / Part Name / Part Description	Pounds
7	7 pcs materials 4140 anneal and harden rc-28-32 black oxide and sand blast rbem625v3006101-1	56

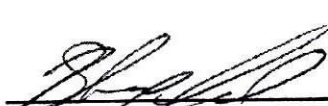
Insp. Type	Scale	Minimum	Maximum	Number	Other
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Customer Requirements:

Harden rockwell

Results:Harden ROCKWE 28. 32. 32. tested as per sampling plan
heat treated to 32rc with black oxide as per cust requested

STATEMENT OF LIMITED LIABILITY (PLEASE READ CAREFULLY): ALL WORK IS ACCEPTED SUBJECT TO THE FOLLOWING CONDITIONS: It is recognized that even after employing all the scientific methods known to us, hazards still remain in metal treating. THEREFORE, OUR LIABILITY SHALL NOT EXCEED TWICE THE AMOUNT OF OUR CHARGES FOR THE WORK DONE ON ANY MATERIAL (FIRST TO REIMBURSE FOR THE CHARGES AND SECOND TO COMPENSATE IN THE AMOUNT OF THE CHARGES). EXCEPT BY WRITTEN AGREEMENT SIGNED BY THE METAL TREATER, THE CUSTOMER, BY CONTRACTING FOR METAL TREATMENT, AGREES TO ACCEPT THE LIMIT IN LIABILITY AS EXPRESSED IN THIS STATEMENT TO THE EXCLUSION OF ANY AND ALL PROVISIONS AS TO LIABILITY ON THE CUSTOMER'S OWN INVOICES, PURCHASE ORDERS OR OTHER DOCUMENTS. IF THE CUSTOMER DESIRES HIS OWN PROVISIONS AS TO LIABILITY TO REMAIN IN FORCE AND EFFECT, THIS MUST BE AGREED TO IN WRITING, SIGNED BY AN OFFICER OF THE TREATER. IN SUCH EVENT, A DIFFERENT CHARGE FOR OUR SERVICES REFLECTING THE HIGHER RISK TO TREATER, SHALL BE DETERMINED BY THE TREATER AND CUSTOMER. THE TREATER MAKES NO EXPRESS OR IMPLIED WARRANTIES AND SPECIFICALLY DISCLAIMS ANY IMPLIED WARRANTY OF THE FITNESS FOR A PARTICULAR PURPOSE OR MERCHANTABILITY, AS TO THE PERFORMANCE CAPABILITIES OF THE MATERIAL AS HEAT TREATED, OR THE HEAT TREATMENT, THE AFORESAID LIMITATION OF LIABILITY STATED ABOVE IS SPECIFICALLY IN LIEU OF ANY EXPRESS OR IMPLIED WARRANTY, INCLUDING ANY IMPLIED WARRANTY OF MERCHANTABILITY OR FITNESS, AND OF ANY OTHER SUCH OBLIGATION ON THE PART OF THE TREATER. No claim for shortages in weight or quantity will be entertained unless presented within five (5) working days after receipt of materials by customer. No claim will be allowed for other such obligation on the part of the TREATER, except by prior written agreement, as above, nor in any case for rupture caused by or occurring during subsequent grinding. Whenever we are given materials with predrillings, reamings, deformity, or rupture of material in treating or straightening, our responsibility shall end with the carrying out of these instructions. Failure by a customer to disclose fully and correctly the kind of material (i.e., proper alloy designation) to be treated, shall result in a charge to be made to cover any additional expense incurred as a result thereof, but shall not change the limitation of liability stated above. Customer agrees there will be no liability on the TREATER in contract for any special, indirect or consequential damages arising whatsoever, including but not limited to personal injury, property damage, loss of profits, loss of production, recall or any other losses, expenses or liabilities allegedly occasioned by the work performed on the part of the TREATER. It shall be the duty of the customer to inspect the merchandise immediately upon its return, and in any event claims must be reported prior to the time that any further processing, assembling or any other work undertaken. OUR LIABILITY TO OUR CUSTOMERS SHALL CEASE ONCE ANY FURTHER PROCESSING, ASSEMBLING OR ANY OTHER WORK HAS BEEN UNDERTAKEN ON SAID MATERIAL. No agent or representative is authorized to alter the above conditions, except by writing duly signed by an officer of TREATER.


 KEANE SHEPHERD
 QUALITY CONTROL
 ATLANTIC HEAT TREATING 2001 LTD